

86702

July-06-12 11:36:58 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Start Date: 7/06/12 **Start Qty:** 8.00 ***8***

Required Date: 8/10/12 **Req'd Qty:** ~~8.00~~ ***Q***

Customer:

Run Start *NR1*

Approvals: Process Plan: Date: 12-07-9

Tooling: _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86702

86702

Page 2

July-06-12 11:36:58 AM

Item ID: D3204-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm
 Start Date: 7/06/12 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		DAS 13 9-89 12/7/26		10	φ		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				10			12/7/27 JF
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/7/30 JF MK 12-07-27

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Picklist Print

July-06-12 11:36:57 AM

Page 1

Work Order ID: 86702

Parent Item: D3204-5

Parent Item Name: Arm

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.250 6061-T6 Bar .375 x 1.25		Purchased	No			100	f	17.2672	0.2913	2.4530528			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	5.2672	
110167	1.8602	
110908	3.407	
MAT002	12	
120243	12	

3.407 and 12/07/21

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DART AEROSPACE LTD		Work Order:	86702
Description: Arm		Part Number:	D3204-5
Inspection Dwg: D3204 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.375	+/-0.010	R 375	—		Visual	
0.750	+/-0.010	.752	—			
R0.50	+/-0.030	R 500	—			
R0.500	+/-0.010	R.500	—			
Ø0.760	+0.005/-0.000	Ø.760	—			
0.080	+/-0.010	.080	—			
2.373	+/-0.005	2.371	—			
Ø0.375	+0.005/-0.000	Ø.375	—			
0.250	+/-0.010	Ø.250	—			
R0.06	+/-0.030	R.060	—			
0.200	+/-0.010	.200	—			

Measured by:	DAS 14	Audited by:	DAS 13	Prototype Approval:	N/A
Date:	12/07/26	Date:	12/7/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

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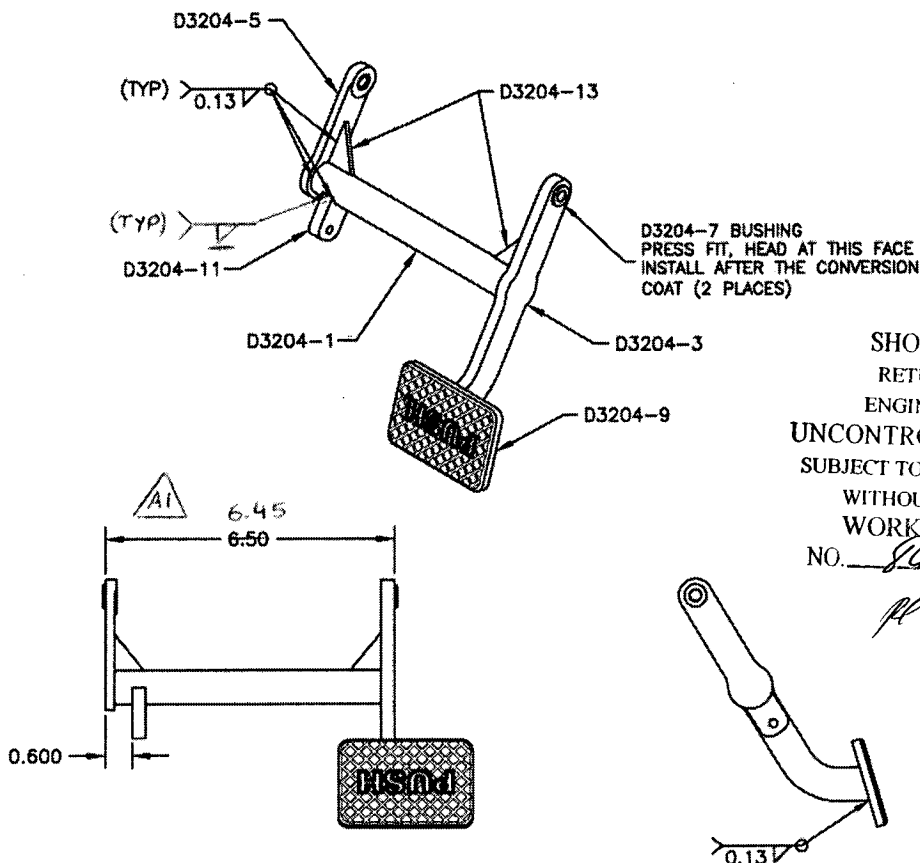
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86702
R12-07-9

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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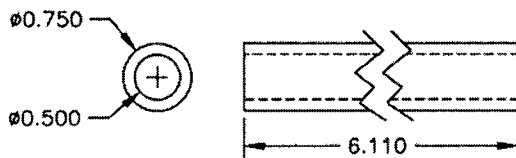
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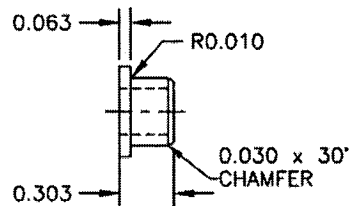
NOTE: Date & initial all entries

DART

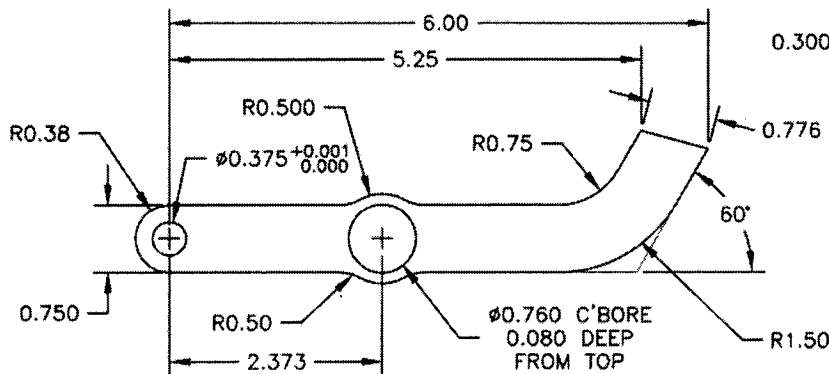
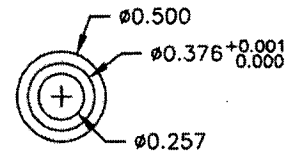
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04.04.05 

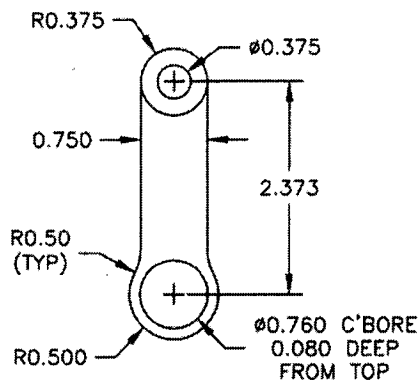
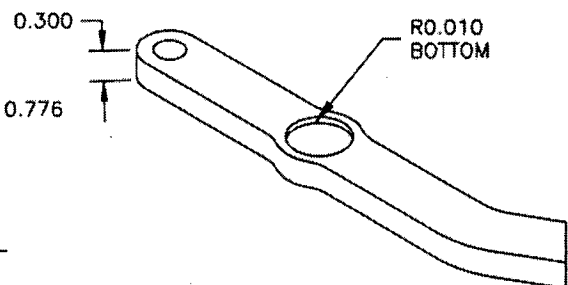
2 **D3204-1 TUBE**
SCALE 1:2



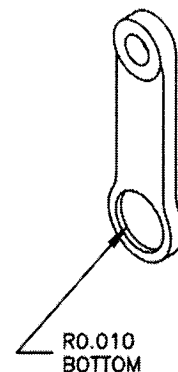
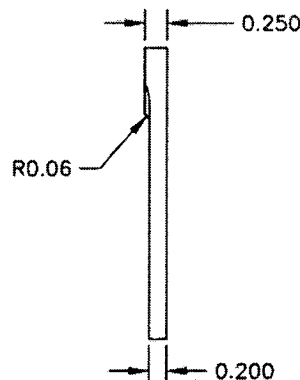
4 **D3204-7 BUSHING**
SCALE 1:1



3 **D3204-3 ARM**
SCALE 1:2



3 **D3204-5 ARM**
SCALE 1:2



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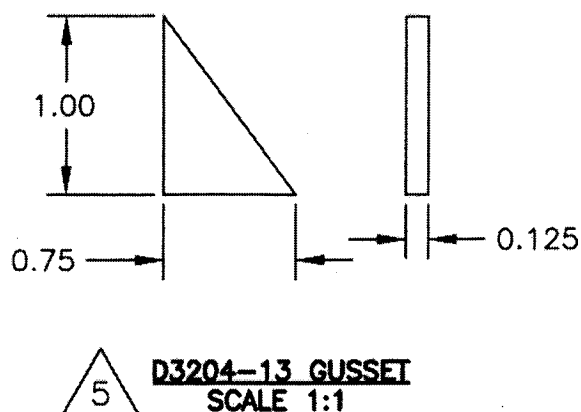
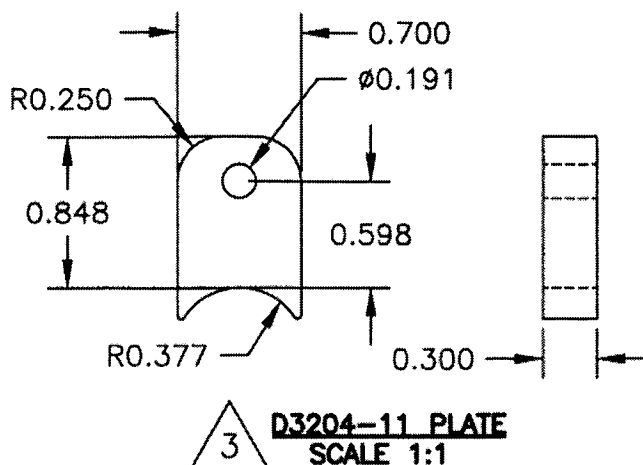
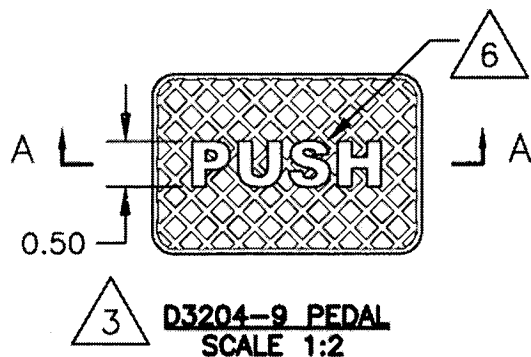
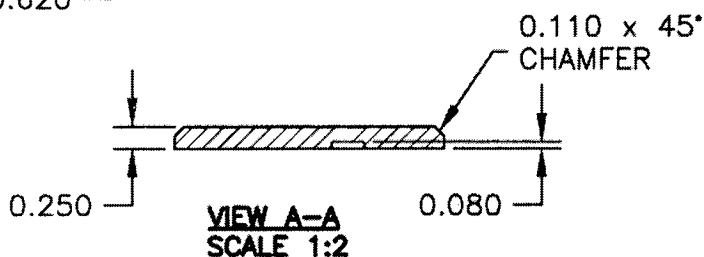
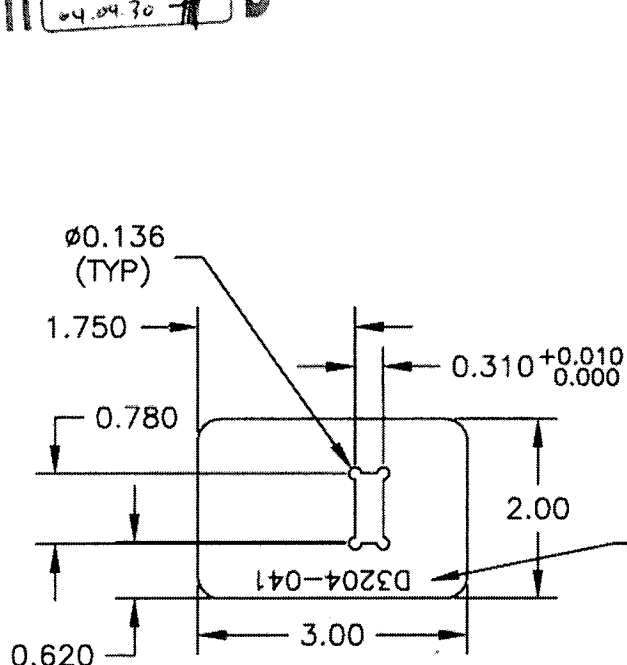
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